

Date: Tuesday, 12/08/2008 9:02:02 AM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : END FITTING ASS'Y  
 Job Number : 41158  
 Estimate Number : 13345  
 P.O. Number :  
 This Issue : 12/08/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D3763041  
 Drawing Number : D3763 REVB  
 Project Number : N/A  
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : B  
 Material :  
 Previous Run : 40957 Due Date : 12/08/2008 Qty: 2 Um: Each  
 Written By :  
 Checked & Approved By : mf 08-08-12  
 Comment : Est Rev:A 08-05-20 new issue DD verified by:ec  
 Est Rev:B 08-07-18 revB as per dwg DD verified by:EC  
 Est Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0 D37631 End Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 End Fitting  
 batch: 40994 x 2 ✓

pl 08-08-12

3.0 D37633 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Tube  
 batch: 40704 ✓

pl 08-08-12

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1  
 1-make a 0.063" chamfer on D3763-1 fitting before ass'y  
 2-assemble as per dwg D3763 using locating pin DT 9014  
 \*\*\*\*\*ensure locating pin is in 0.221" hole\*\*\*\*\*

X2

3-weld as per dwg D3763 QSI004  
 Alum. rod Batch: M104855

pl 08-08-12

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Drawing Name: END FITTING ASS'Y

Job Number: 41158

Part Number: D3763041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 08-08-12 (2)

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/08/12 (42)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08/08/12 (2)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08/08/12 (2)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: 6A

SAD 08/08/12 (2)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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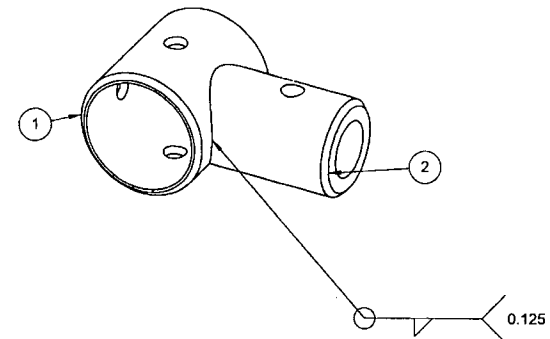
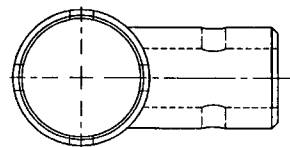
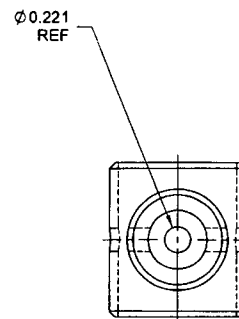
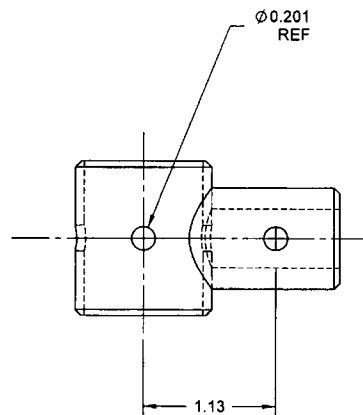
Comment: FINAL INSPECTION/W/O RELEASE

208108/14

Job Completion



MF 08-08-14



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

# **D3763-041 END FITTING ASSY**

RELEASED  
08.07.04

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3763	SHEET 1 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	END FITTING	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.03 lbs
  - 8) WELD: PER DART QSI 004

# 41158